

Date: Thursday, 5/11/2006 10:42:00 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE BLOCK
 Job Number : 27073
 Estimate Number : 10324
 P.O. Number : N/A Part Number : D1049
 This Issue : 5/11/2006 S.O. No. : N/A Drawing Number : D1049 REV A
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : A
 Previous Run : 24980 Material : N/A
 Due Date : 5/30/2006 Qty: 50 Um: Each
 Written By : See comment below
 Checked & Approved By : 06.05.11
 Comment : Est RevC 02.04.10 Re-format NG

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6B0750X00250

6061-T6 Bar .750 x .250



Comment: Qty.: 0.1749 f(s)/Unit Total : 8.7465 f(s)

Material: 6061-T6 bar .750 wide x .250 thick.

Batch M17869

J.G

06/05/18

51

2.0

SHEAR

SHEAR



Comment: SHEAR

Cut Blanks: 2.000" long

J.G

06/05/18

51

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per folio FA217 & Dwg D1049

2-Deburr

J.G

06/05/19

51

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.G

06/05/19

51

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.G

06/05/19

51

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/05/26

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE BLOCK

Job Number: 27073

Part Number: D1049

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

DL 06/05/23 51

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

am 06-05-25 (51)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

AL 06/05/25 51

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5109

U 06/05/25 (51)
AL 06/05/25 (51)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

D 06/05/26 (51)

Job Completion



W 06/05/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

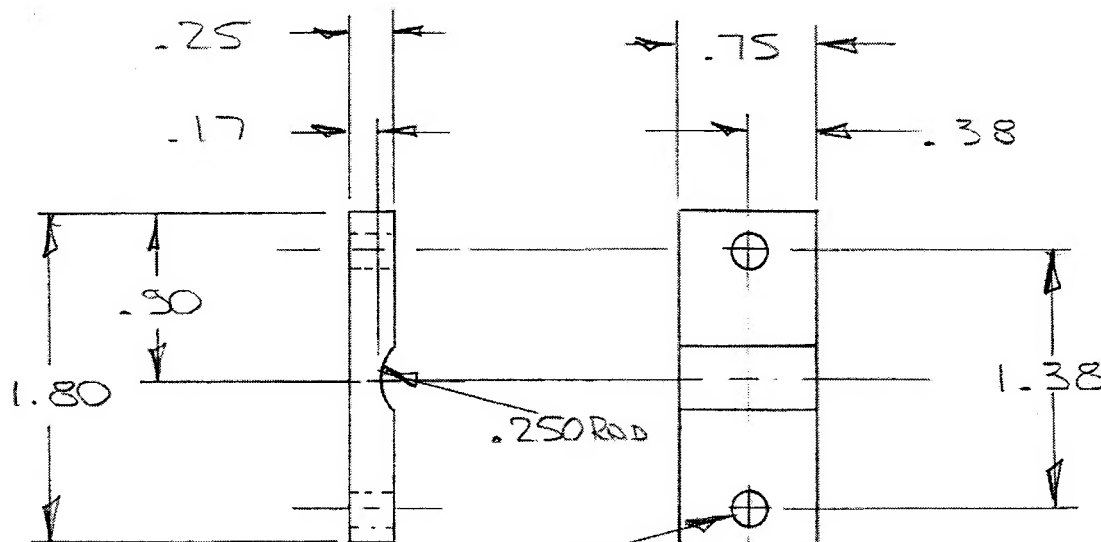
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

RELEASED
97/09/02 BW



.203 DIA.
TYP

MATERIAL : 5052-H32

FINISH : POWDER COAT



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 21073

REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.		RIVET CODE SHALL BE PER NAS 523		PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC/VENDOR
DRAWN			BASIC CODE	DIA. DASH NO. W-HEAD NEAR SIDE P-HEAD FAR SIDE	CONTRACT NO.		DART DART AERO ACCESSORIES INC. VANCOUVER CANADA		
APPROVED			D-DIMPLE DIGIT-NO OF SHEETS C-COUNTERSINK	LENGTH DASH NO. W-SPOTWELD	DATE	1992			
DESCRIPTION OF CHANGE	REQUIREMENTS — UNLESS OTHERWISE SPECIFIED		BASIC CODES		STRESS		TITLE		
	GENERAL		8-MS20470AD 8-MS20426AD		CHECKED		CODE		
	1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS 125 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER INCH - 8 - 32x2 5. HOLES PER AND 10087		1. TOLERANCES — .001 ± .002 2. ANGLES .001 ± .010 3. PARALLELISM .0025 4. ECCENTRICITY .0025 MAX 5. SYMMETRY ABOUT ALL M/C CENTRE LINES .005		CLIENT		DWG NO. D1049		
	REPORT ALL DISCREPANCIES — DO NOT SCALE				SCALE	1:1	SHT	OF	REV.